

Work Order ID 97121

February-14-13 2:31:40 PM

97121

Page 1

Item ID: D3335

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spring

Start Date: 2/14/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/28/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

130219

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3335

Rev D

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

19139

Manufacture as per dwg D3335

Possible supplier: Victory Springs

CZ 13/02/20 (12)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

13/2/25 (12)

120

QC5- Inspect part completeness to step on W/O

0.00

SMP

120

B.225

QC

Memo

0.00

Quality Control

12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Date:

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Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

St 39

0.00

130

Packaging

Memo

0.00

Packaging

12x

EP 13/07/02

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/7/4

mf

13-7-2

NCR: Yes / No

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QA Closed: _____ Date: _____

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Picklist Print

February-14-13 10:50:38 AM

Page 1

Work Order ID: 97121

Parent Item: D3335

Parent Item Name: Spring

Start Date: 2/14/13

Required Date: 2/28/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A04.11.23New issueKJ/JLM
esr B 07.04.04 rev C dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3335-P Spring		Purchased	No			110	f	0.0000	1	12			

43/2/20 (12)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

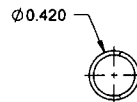
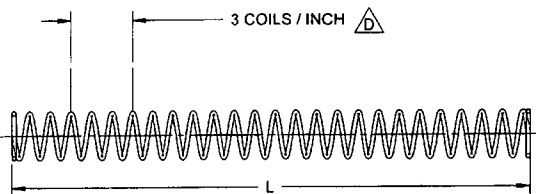
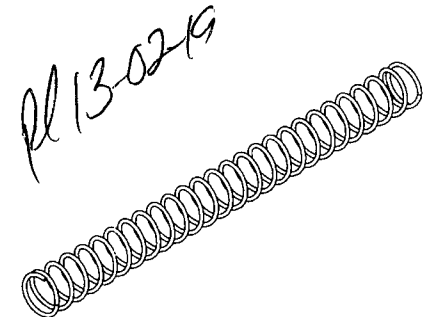
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SPECIFICATION CONTROL DRAWING

97121



D3335-X SPRING

DART P/N	L (in)	
D3335-1	4.38	△
D3335-3	7.63	△
D3335-5	1.20	△

RELEASED
9/2/05

NOTES:

- 1) MATERIAL: SPRING STEEL, Ø0.035 WIRE
- 2) FINISH: LPS PROCYON
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) POSSIBLE SUPPLIER: VICTORY SPRINGS, LENGTH REQUIRED: 12"

REV.	DESCRIPTION	BY	DATE
D	ADD 3 COILS / INCH	PH	08.06.05
C	ADDED D3335-5, CHANGED FINISH	RF	05.12.19
B	4.38 WAS 4.13; 7.63 WAS 6.80	MB	05.08.11
A	NEW ISSUE	MB	04.12.07
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB	DRAWING NO.	REV. D
CHECKED	MB	D3335	SHEET 1 OF 1
MFG. APPR.	MB	TITLE	SCALE
APPROVED	MB	SPRING	NTS
DE APPR.	MB	DATE 08.06.05	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19139

Purchase Order Date 2/20/13

PO Print Date 2/20/13

Page Number 1 of 1

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

866 230 5312

866 230 5338

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
2/20/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3335-P	Spring	2/26/13 Yes	12.00 f	FedEx Pl collect	\$15.2800	\$183.36

Special Inst: AS PER DWG D3335 REV. D
B97121

PO Total:

\$183.36

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 2/20/13

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO



PACKING SLIP

26507

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
20-Feb-13		PO19139		FedEx	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
12	D3335-P Compression Spring 12" Length				
GST#	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd	DATE: 21/02/2013	
PART/DRAWING #: D3335-P Compression Spring	PO # 19139	
DESCR: 12" Length Compression Spring	QUANTITY: 12	

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES	
Material type	SS302	Yes		
Material diameter	0.035	0.035		
Coil I.D.				
Coil O.D.	0.420" +/- 0.012"	0.430"		
Pitch	0.330"	0.315"		
Free Length	12"	12"		
End Type	Closed-Not Ground	Yes		
Finish		None		

COMMENTS

Mill Certificate attached: No
Material Heat Number:

Inspected by: *Chris Burrowes*

